

# Work Order ID 96068

January-18-13 1:10:53 PM

**\*96068\***

Page 1

Item ID: D4634-043  
 Revision ID:  
 Item Name: Middle, Center Ceiling Panel Assembly

Accept

**\*N9000040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Start Date: 1/18/13 Start Qty: 1.00 **\*1\***  
 Required Date: 2/01/13 Req'd Qty: 1.00 **\*1\***

Cust Item ID:  
 Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-01-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4634	A								
100		0.00							
<b>*100*</b>									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D4634-043								
	2- Install led lights								
	3- Install Air valves								
	4-Install wiring harness								

13/04/10  
13/04/25

# Work Order ID 96068

January-18-13 1:10:53 PM

**\*96068\***

Page 2

Item ID: D4634-043

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/18/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00							
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

*Handwritten signatures and dates:*  
 1/23/13  
 1/31/13  
 1/31/13  
 1/31/13

# Picklist Print

January-18-13 1:10:57 PM

Page 1

Work Order ID: 96068

\*96068\*

Parent Item: D4634-043

\*D4634-043\*

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL  
12/11/08 Doc Release DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D4634-3</del> D4634-143 <i>DL</i>		Manufactured	No	898238		100	Each	0.0000	1	1			
* <del>D4634-3</del> *									**				
Middle, Center Ceiling Panel													
D4638-1		Manufactured	No			100	Each	0.0000	1	1			
*D4638-1*									**				
LED Light													
D4646-1		Manufactured	No	92966		100	Each	24.0000	2	2			
*D4646-1*									**				
Plenum Cap Assembly													
<div> <div>Location</div> <div>ST117</div> <div>92968</div> </div> <div> <div>Loc Qty</div> <div>24</div> <div>24</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4647-1		Manufactured	No			100	Each	4.0000	1	1			
* <del>D4647-1</del> *									**				
Doubler													
<div> <div>Location</div> <div>ST116</div> <div>92969</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4647-3		Manufactured	No			100	Each	15.0000	2	2			
* <del>D4647-3</del> *									**				
Angle													
<div> <div>Location</div> <div>ST117</div> <div>92970</div> </div> <div> <div>Loc Qty</div> <div>15</div> <div>15</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

*DL*  
13/04/25  
D4638-1  
13/04/25  
D4646-1  
13/04/25

# Picklist Print

January-18-13 1:10:57 PM

Page 2

Work Order ID: 96068

Parent Item: D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

\*96068\*

\*D4634-043\*

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 1.00

Required Qty: 1.00

D4652-1 Manufactured No

100 Each

24.0000

2

2

\*D4652-1\*

Air Valve, 1.16 ID Disk Type

\*\*

2

DAS  
07  
2-89  
13/04/25

Location

Loc Qty

Loc Code

ST117

24

93032

24

D4664-5 Manufactured No

100 Each

40.0000

6

6

\*D4664-5\*

Spacer

\*\*

Location

Loc Qty

Loc Code

ST117

40

93071

40

D4694-043 Manufactured No

100 Each

0.0000

1

1

\*D4694-043\*

Middle Channel Assembly

\*\*

D4694-7 Manufactured No

100 Each

0.0000

1

1

\*D4694-7\*

Channel

\*\*

D4712-041 Manufactured No

100 Each

0.0000

1

1

\*D4712-041\*

Bracket Assembly

\*\*

D4728-053 Manufactured No

100 Each

2.0000

1

1

\*D4728-053\*

Cabin Lights #2

\*\*

1

DAS  
07  
2-89  
13/04/25

Location

Loc Qty

Loc Code

ST120

2

93457

2

# Picklist Print

January-18-13 1:10:57 PM

Page 3

Work Order ID: 96068

\*96068\*

Parent Item: D4634-043

\*D4634-043\*

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 1.00

Required Qty: 1.00

D4732-21 Manufactured No

100 Each 10.0000 1 1

~~\*D4732-21\*~~

Label

NA ok

\*\*

Location

Loc Qty

Loc Code

ST120

10

93173

10

D4732-25 Manufactured No

100 Each 10.0000 1 1

~~\*D4732-25\*~~

Label

NA ok

\*\*

Location

Loc Qty

Loc Code

ST120

10

93234

10

MPNY-750S-9-C Purchased No

100 Each 100.0000 3 3

~~\*MPNY-750S-9-C\*~~

Mounting Pad

NA ok

\*\*

Location

Loc Qty

Loc Code

ST390

100

124058

100

MS20426AD3-3 Purchased No

100 Each 7,521.000 4 4

~~\*MS20426AD3-3\*~~

Rivet

NA ok

\*\*

Location

Loc Qty

Loc Code

GA

493

122814

493

ST316

699

119109

282

19099

417

ST333

6329

121011

121

123352

6208

January-18-13 1:10:57 PM

Shop Packet Print

Page 3

# Picklist Print

January-18-13 1:10:57 PM

Page 4

Work Order ID: 96068

Parent Item: D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

\*96068\*

\*D4634-043\*

Start Date: 1/18/13

Required Date: 2/01/13

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

100

Each

403.0000

2

2

~~\*MS21059L3\*~~

Nut Plate

N/A

\*\*

Location

Loc Qty

Loc Code

ST316

203

123900

8

124291

195

ST506

200

124308

200

MS24694-S5

Purchased

No

100

Each

538.0000

2

2

\*MS24694-S5\*

Screw

\*\*

(2)

7

D4634-043

13/04/25

Location

Loc Qty

Loc Code

ST302

538

18949

102

19073

436

PLT1.5M-M

Purchased

No

100

Each

0.0000

3

3

\*PI T1 5M-M\*

Tie Wrap

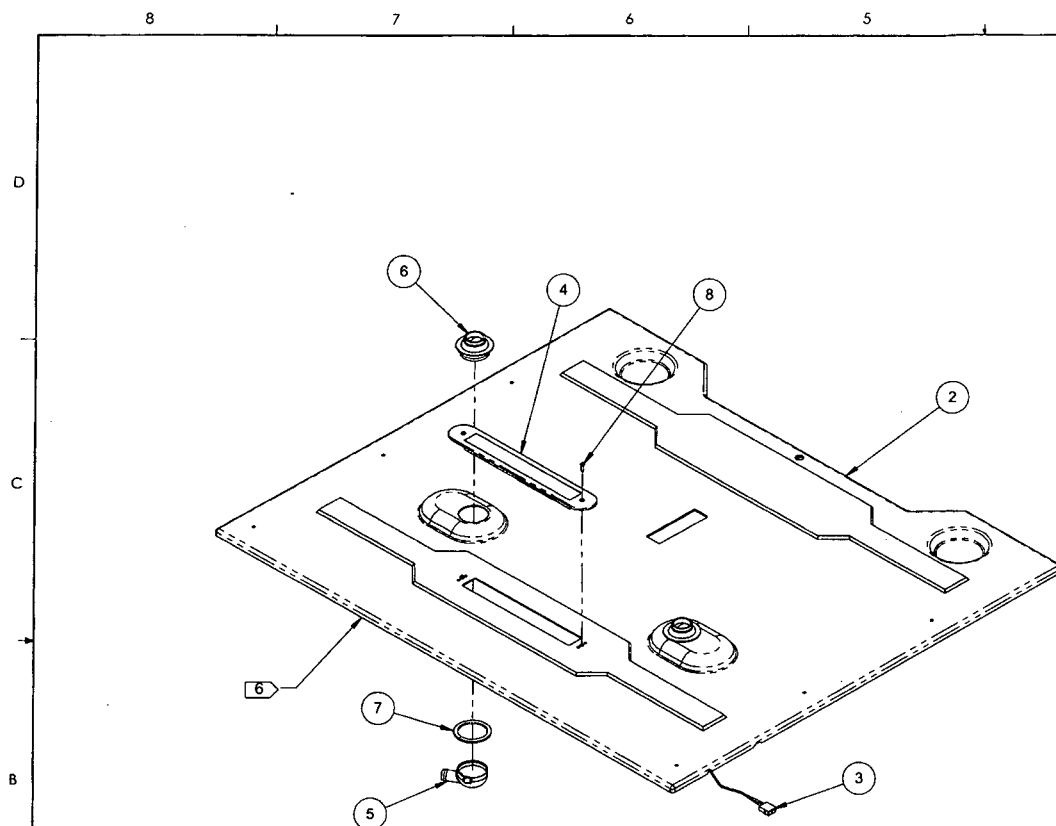
\*\*

(3)

D4634-043

13/04/25

124363



ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
4	1	D4638-1	LED LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3	MOUNTING NUT
8	2	MS24694-S5	SCREW
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

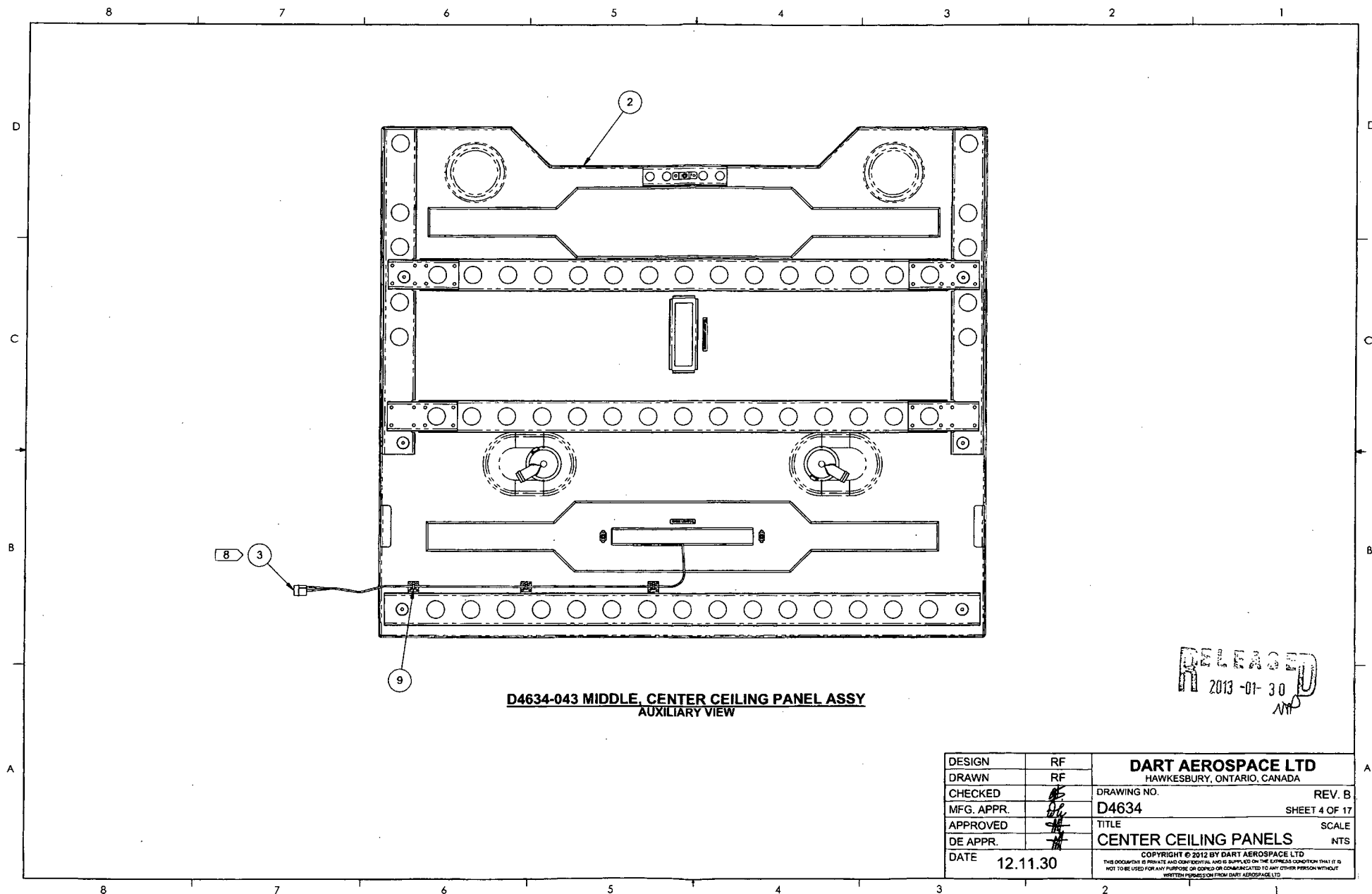
**D4634-043 MIDDLE, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

**RELEASED**  
2013-01-30  
JP

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4634	SHEET 3 OF 17
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
DATE	12.11.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



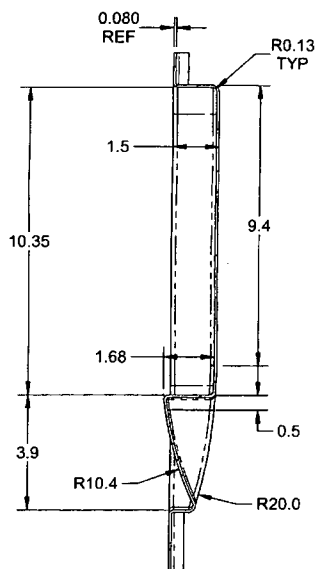
RELEASED  
2013-01-30  
AM

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4634</b>	SHEET 4 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CENTER CEILING PANELS</b>	NTS
DATE	12.11.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

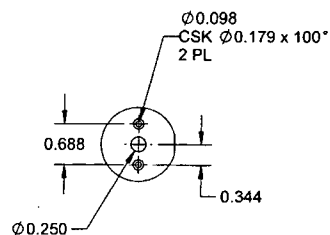


8 7 6 5 4 3 2 1

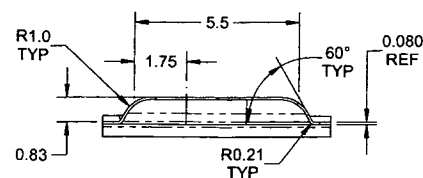
D



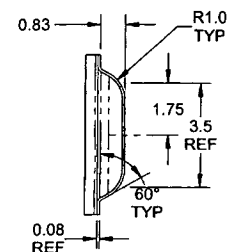
**SECTION G-G** C5-11  
SCALE 4X



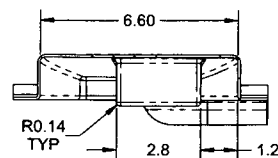
**DETAIL C** B7-10  
SCALE 4X B4-12  
B4-14



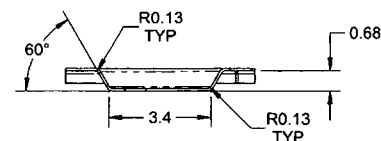
**SECTION D-D** B6-11  
SCALE 2X C4-13  
C4-15



**SECTION E-E** B5-11  
SCALE 4X C4-13  
C5-15

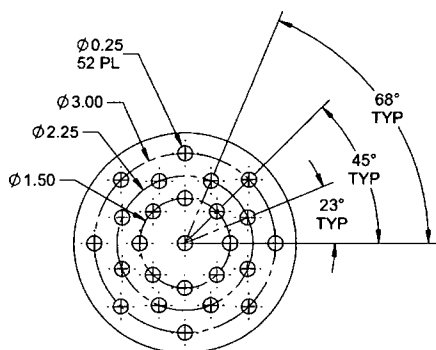


**SECTION H-H** C5-11  
SCALE 2X

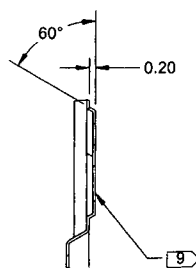


**SECTION J-J** B6-13  
SCALE 2X

B



**DETAIL B** B7-10  
SCALE 4X  
2 PL



**DETAIL L** B2-13  
SCALE 4X C2-13  
TYP B2-14  
C2-14

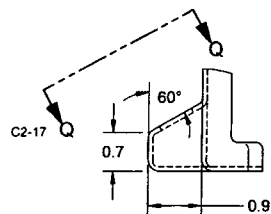
A

RELEASED  
2013-01-30

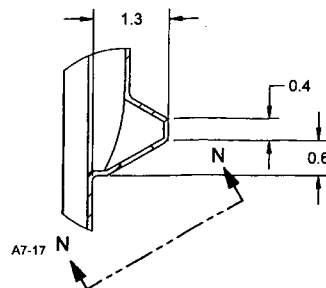
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. B
MFG. APPR.	RF	SHEET 16 OF 17	
APPROVED	RF	TITLE <b>CENTER CEILING PANELS</b>	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
DATE	12.11.30	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

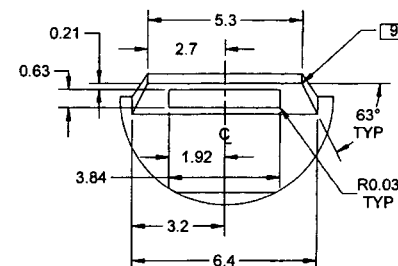
8 7 6 5 4 3 2 1



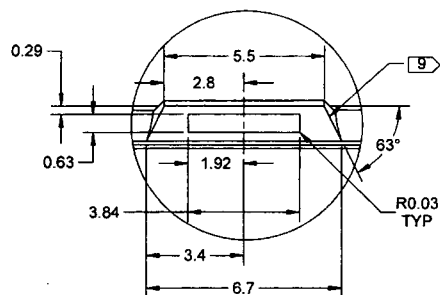
**DETAIL P** B3-14  
SCALE 2X



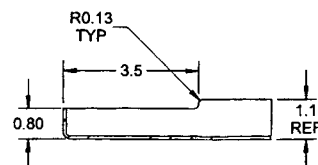
**DETAIL M** C3-10  
SCALE 2X



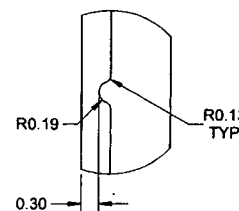
**DETAIL Q** B4-15  
SCALE 0.5X D8-17



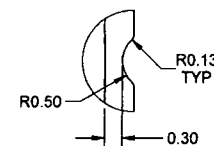
**DETAIL N** C5-17  
SCALE 0.5X B4-15



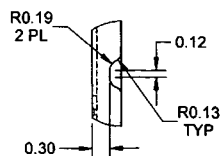
**SECTION O-O** B6-14  
SCALE 1.3X



**DETAIL R** B3-10  
SCALE 4X C3-10  
B2-12



**DETAIL S** B3-10  
SCALE 4X C2-12



**DETAIL T** C2-14  
SCALE 4X

RELEASED  
2013-01-30

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4634</b>	SHEET 17 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CENTER CEILING PANELS</b>	NTS
DATE	12.11.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			